

Work Order ID 98634

March-18-13 10:30:59 AM

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Item ID: D2809 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bushing
 Start Date: 3/18/13 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 3/21/13 Req'd Qty: 24.00 *24* Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2809	Rev A1								
100		0.00							
100	Hardinge CNC LATHE SMALL								
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	Machine as per Folio FA204								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

13-03-19 24 0

13-03-19 24 0

13-3-20 24 0

DAS
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125	Chemical Conversion Coat per QSI005 4.1	0.00							
125									
HandFinish	Memo	0.00							
Hand Finishing									
130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10:00 OVEN TEMPERATURE: 325 FINISH TIME: 10:30	0.00							
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									

24 13-3-20

24X 2 M/ 13/03/22

m 24245

24 13-3-22

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location <i>GA</i>	0.00							
170									
Packaging	Memo	0.00				24X			<i>SP</i>
Packaging									13-3-22
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							13/3/25 <i>GA</i>
Quality Control									<i>mf</i> 13-3-25

Picklist Print

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Parent Item: D2809

Parent Item Name: Bushing

Start Date: 3/18/13

Required Date: 3/21/13

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP C02.03.07Now turned in houseNG IPP REV:D 11.12.08 added powdercoat per dwg DD
VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500 6061-T6 Round Bar .500"		Purchased	No			100	f	89.2320	0.0995	2.5136842 3.3631		13-03-19	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT012	89.232	
114488	3.994	
123483	1.238	
124029	24	
124681	60	

3.3631

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<input checked="" type="checkbox"/> First Article	<input type="checkbox"/> Prototype
<p>1. Design Review</p> <p>2. Material Selection</p> <p>3. Tooling Design</p> <p>4. Tooling Fabrication</p> <p>5. First Article Inspection</p> <p>6. Process Validation</p> <p>7. Production Ramp-Up</p>	<p>1. Design Review</p> <p>2. Material Selection</p> <p>3. Tooling Design</p> <p>4. Tooling Fabrication</p> <p>5. First Article Inspection</p> <p>6. Process Validation</p> <p>7. Production Ramp-Up</p>

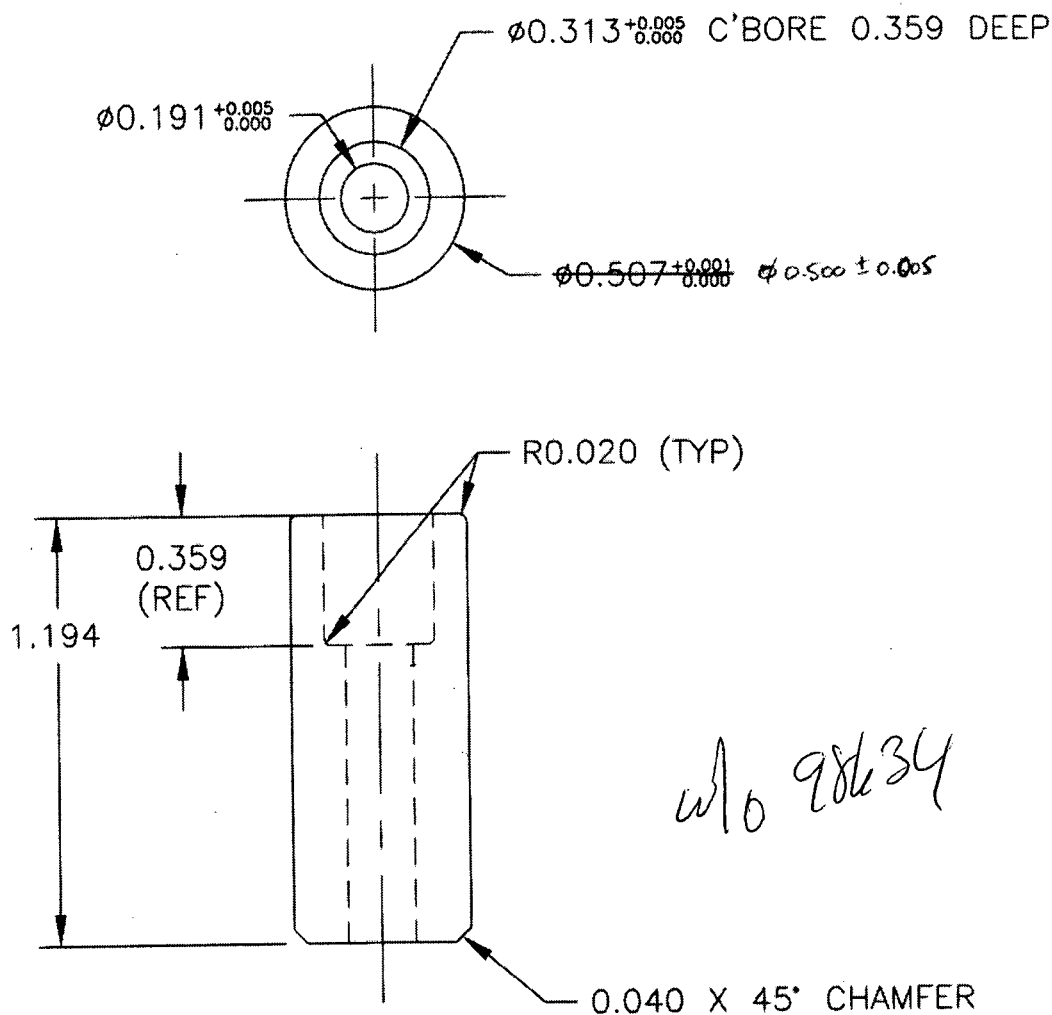
Measured by:	<i>SS</i>	Audited by:	<i>(DAS 04 9-89)</i>	Prototype Approval:	N/A
Date:	13-03-19	Date:	13.3.20	Date:	N/A

ed by	Approved
M <i>[Signature]</i>	<i>[Signature]</i>



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2809	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	# CP 01.04.26	ADD POWDER COAT; $\phi 0.500$ WTS $\phi 0.507$	

RELEASED
00.11.13



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020

MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8)

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PER DART QSI 005 4.3